# Work Order ID 100156 \*100156 \*100156 \*100156\*

April-18-13 1:19:31 PM

Quality Control

Item ID: D4030-041 Accept \*N900040100\* Setup Start Revision ID: Item Name: Long Basket Assembly (350) **Start Date:** 4/18/13 Start Qty: 1.00 Cust Item 1D: Required Date: 5/02/13 Req'd Qty: 1,00 **Customer:** Reference: \ Run Process Plan: MLJ Date: 13-04-18 Tooling: Date: \_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp Revision Nbr Draw Nbr D4030 C 100 Pick Kit 0.00 \*100\* Packaging Memo 0.00 Packaging 110 Assemble as per dwg 0.00 \*110\* HandFinish 0.00 Memo Hand Finishing \*\*\*\*Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label \*\*\*\* 120 QC5- Inspect part completeness to step on W/O \*120\* Memo

									DQA:	Date:	
NCR: Yes	s / No			WORK ORDER	NON-COI	NFORN	ИANCE / UP	DATE	QA Closed:	Date:	1. T. J. C.
Mark Order	· · · · ·			DISPOSITI	ON			AGAINST	DEPARTMENT	/PROCESS	
Work Order: Part No. NCR No.	•				ework Scrap e-as-is pdate	Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	Rec/Sto	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	T .			Description of work order	update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	or Non-conformance	e Cł	nief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling Operator Material											
Other Process	j							!			

**FAULT CATEGORY** 

#### General **Landing Gear** Pressure/Forced Grain Ovalized Bend Bending Temperature/Cure Over/Under tolerance BOM/Route Centre Not Concentric to O/S Hardware Weld Part incorrect Inspection Incomplete Cracks Broken/Damaged Wrong Stock Pulled Part Lost/Missing Instructions Incomplete/Unclear Crushed/Crimped. Burrs Part Moved Maintenance Contamination Cuffs Mislabeled Positioned Wrong Heat Treat Countersink Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Offset Ripples in Bend Drill Holes Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Turning Sequence Finish Folio Wave/Twist in Tube **Outside Dimensions**

Training Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## Work Order ID 100156 🚜 🖈 💌

April-18-13 1:19:31 PM

\*100156\*

Item ID: Revision ID: Item Name: Start Date:	D4030-041 Long Basket 4/18/13	Assembly (350) Start Qty: 1.00	*1*	Accept	*N900		100	ገ*	Setup Star Sto	I VI	S1* S2*
Required Date Reference:		Req'd Qty: 1.00	*1*		Cust Item ID: Customer:						
Approvals:	00	an:	_			ate:		I	Run Stai Sto	1/1	R1* R2*
Sequence ID/ Work Center I  130 *120* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	/US)51	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code		Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00				M\	5 13	7- <u>02-</u> C	13

Q (3-05-)

											DQA:	Date:	
NCR:	Yes	/ No	!			WORK ORDER NON-O	O	NFORM	MANCE / UP	DATE	QA Closed:	: Date:	
Work Orde	or:			•		DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part f	Part No.					Rework Skid-tube Scrap Machining Use-as-is Thermoforming Work Order Update Large Fab			Machining noforming	Small Fab Prod. Eng. Coor. Finishing Rec/Store/Packaging Supplier			Engineering Quality Other
Root		****			Descri	ption of work order update	ļ	nitial	Ac	tion	Sign &		
Cause		Date <sup>1</sup>	Step	Qty	,	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling		:										*	
Operator		ĺ	1										
Material		1				م م							
Setup						C							
Other		1											
Process		1											
Supplier													
Training		1											
Unapproved		!											
						F	AUL	T CATE	GORY				
Landi	ng G	ear				Genera!		-					_
		Bending				Bend		Grain		_	Ovalized	_	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re	Ĺ	Over/Unde	r tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	on Incomplete		Part Incorre	ect	Weld
	П	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/N	lissing	Wrong Stock Pulled

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Cuffs

Heat Treat

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:19:35 PM

Work Order ID: 100156

\*100156\*

Parent Item:

D4030-041

\*D4030-041\*

Parent Item Name: Long Basket Assembly (350)

**Start Date: 4/18/13** 

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

IPP Rev:B as

per dwg revB DD 10.04.20 verified by:EC

IPP Rev:C as per dwg

revC DD 10.08.18 verified by:EC

IPP Rev D 12.03.27 per NCR12-

1239 EC verified by:JLM

	239 EC Verified												
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200		Manufactured	No				Each	19.0000		1	<del></del> -		<u></u>
*D4086-20 Placard, Max Load	ገበ*								**			1_	·
				<u>Location</u>	<u>n</u>	Loc	<u>Qty</u>	Loc Code					
				ST093			19						
					88611		5						
					96251		4		-6	· · · ·			
D2530					98519		10		Ī	J 513			1
		Manufactured	No			100	Each	15.0000	1	1			
*D2530* Handle Weldment									**				<del></del>
				Location	<u>1</u>	Loc	<u>Qty</u>	Loc Code					
				ST205	•		10						
					87086		10		7	F7086			
				ST255			5						
					86369		5						
02535		Manufactured	No			100	Each	50.0000	2	2		1	
*D2535*									**	2 \		/ /	
pring							•		_			<b>U</b>	
				Location	<u>l</u>	Loc (	Oty	Loc Code					
				ST011			50						
	•				96248		50			9624	<b>~</b>		

NCR: Y	R: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE  QA Closed: Date:													
													ate:	
Work Orde	r:				DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
					Rework	7		Skid-tube	Crosstube			Water Je	t	Engineering
Part N	0.				Scrap		1	Machining	Small Fab		Pro	d. Eng. Coo	∵∏	Quality
<u> </u>					Use-as-is		1	oforming	Finishing		Rec/Stor	e/Packagin		Other
NCR N	0.			<del></del>	Work Order Update	╛		Large Fab	Composite			Supplie	r	
Root				Descri	ption of work order update		Initial	Acti	on		Sign &	-		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Descri	iption		Date	Verificati	on	QC Inspector
Doc/Data											•			
Equip/Tooling	_													
Operator		1					ļ							
Material														
Setup														
Other						İ								
Process									,					
Supplier Training														
Unapproved											·			
Ollapproved		<u> </u>	<del></del>			FAUL	T CATE	GORY			J	<u> </u>		
Landin	g Gear	-12			General									
	Bending				Bend		Grain				Ovalized			Pressure/Forced
	Centre N	lot Conce	ntric to O,	/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct		Weld
	Crushed	/Crimped	-		Burrs		Instruct	ions Incomplete/U	Inclear		Part Lost/M	issing		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance			Part Moved			
[	Heat Tre	at			Countersink		Mislabe	led		匚	Positioned V			1
	Inspection	on Strip ir	Tube		Cut Too Short	L	Misread	l		<u> </u>	Power Loss/	Surge		Other
	Ripples i	n Bend		. [	Drill Holes		Offset							
	Torque \	Naves in	Extrusion		Drawing ·		Out of C	Calibration						

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:19:35 PM

Work Order ID: 100156

D4030-041

\*100156\*

Parent Item:

Parent Item Name: Long Basket Assembly (350)

\*D4030-041\*

**Start Date:** 4/18/13 Start Qty: 1.00

Required Date: 5/02/13

Required Qty: 1.00

D2537

Manufactured

100

Each

96.0000

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Bushing									$\mathcal{O}_{\mathcal{I}}$	
			<b>Location</b>	<u>1</u>	oc Oty	Loc Code				
			ST008		24					
			99011		24					
			ST011		72					
			92711		8					
			94713		40			94713		
D2012 041			98426		24					
D3913-041	Manufactured	No		100	Each	0.0000	1	1		
*D3913-041* Long Basket Base Assemby, 350			100164.				**		BN 13-5-1.	
D3914-041	Manufactured	No		100	Each	0.0000	1	1		
*D3914-041* Long Basket Lid Assembly (350)			100172				**		Bl 13-5-1.	
D3917-3	Manufactured	No		100	Each	90.0000	6	6 -	1	
*D3917-3*							**		W 13/4/30 (	

Location	Loc Oty	Loc Code	
ST072	90		
92514	1		
94136	5		
94643	24		94643
97710	60		7 (-

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONFO	ORN	MANCE / UPDATE		OA Class de	D-4	
		<del></del>			· · · · · · · · · · · · · · · · · · ·	<del></del>		and the second s		QA Closed:	Date:	
					DISPOSITION			AGAINST	DE	PARTMENT,	PROCESS	
Work Orde	er:				Rework	, <b> </b>		Skid-tube Crosstube		1	Water Jet	Engineering
Dowt N	lo.				Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
Part N	10.							i	e/Packaging	Other		
NCR N	lo				Work Order Update	<b>    </b>		Large Fab Composite		11.00,0101	Supplier	1 -
TTCTT 1						1		0- · · <u></u> ,				
Root				Descri	ption of work order update	Initi	al	Action		Sign &	-	
Cause	Date	Step	Qty	(	or Non-conformance	Chief	Eng	Description		Date	Verification	QC inspector
Doc/Data							İ					
Equip/Tooling										:		
Operator							Ì					
Material												
Setup				ļ								
Other												
Process							ļ					
Supplier	_											
Training												
Unapproved				<u> </u>		L				<u> </u>		<u> </u>
						AULT C	ATEC	ORY				<del></del>
Landir	ng Gear				General					1		7,0,,,,,,,,
	Bending				Bend	Gra			-	Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	O/S	BOM/Route	<b></b>	rdwai 		-	Over/Under	<u> </u>	Temperature/Cure
	Cracks				Broken/Damaged	$\vdash$		on Incomplete	$\vdash$	Part Incorre	<del> </del>	Weld
	Crushed/	Crimped.		.	Burrs	<del></del>		ons Incomplete/Unclear	$\vdash$	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs		, ,		Contamination	Ma	ainte	nance	1	Part Moved		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:19:35 PM

Work Order ID: 100156

D4030-041

\*100156\* \*D4030-041\*

Parent Item:

Parent Item Name: Long Basket Assembly (350)

**Start Date: 4/18/13** Start Qty: 1.00

Required Date: 5/02/13 Required Qty: 1.00

D3953-3

Manufactured

100

Each 34.0000

Gas Spring Stud, Lid

<u>Location</u>	Loc Oty	Loc Code
GA	1	
87592	1	
ST076	21	
88494	14	
94744	7	
ST176	12	
99169	12	

D3953-7

Manufactured

Manufactured

No

100 Each 58.0000

45

2

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Spring Spacer

D3953-9

Location	<u>Lo</u>	c Oty	Loc Code
ST076		58	
94669		34	
99148	-	24	
	100	Each	65.0000

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Gas Spring Washer

Location Loc Qty Loc Code ST076 94719 20

95127

NCR: Yes	/ No				WORK ORDER NON-CO	INC	FORM	IANCE / UPI	DATE	Q	A Closed:	Dat	e:	
			-			Т			AGAINST D	FP4	ARTMENT/	PROCESS		
Work Order: Part No.					DISPOSITION  Rework  Scrap  Use-as-is  Work Order Update		N Therm	Skid-tube Machining Moforming Large Fab	Crosstube Small Fab Finishing Composite		Proc	Water Jet J. Eng. Coor e/Packaging Supplier		Engineering Quality Other
NCR No.							1	Λ.	tion	丁	Sign &		$\neg \tau$	
Root Cause	Date	Step	Qty		iption of work order update or Non-conformance		nitial ef Eng		ription	-	Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
Опарриочес					F	AUL	T CAT	GORY						
Landing	Bending Centre N Cracks Crushed Cuffs Heat Tro Inspecti Ripples Torque	Not Conco I/Crimped eat ion Strip	d. n Tube ı Extrusi	-	General  Bend  BOM/Route  Broken/Damaged  Burrs  Contamination  Countersink  Cut Too Short  Drill Holes  Drawing  Finish		Main' Mislat Misre Offset Out o	tion Incomplete ctions Incomplete cenance peled ad f Calibration f Sequence	e/Unclear		Ovalized Over/Unde Part Incorre Part Lost/N Part Move Positioned Power Los	ect Aissing d Wrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
					Folio		Outsi	de Dimensions						

DQA: \_\_\_\_

Date: \_

Folio

Wave/Twist in Tube H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:19:35 PM

Work Order ID: 100156

D4030-041

\*100156\*

\*D4030-041\*

Location

Parent Item Name: Long Basket Assembly (350)

**Start Date: 4/18/13** 

Required Date: 5/02/13

Start Qty: 1.00

Required Oty: 1.00

D3953-17

Gas Spring Spacer

Parent Item:

Manufactured

100

Loc Qty

Each

44.0000

Loc Code

\*\*

D3953-19

Manufactured

ST076 44 94578 12 97100 12 97696 100

20 Each 16.0000

\*\*

\*D3953-19\* Gas Spring Bracket

Manufactured

Manufactured

No

Location Loc Qty ST077 16 92819 97691 12 100 Each

18.0000

Loc Code

Loc Code

\*\*

\*D3953-21\*

Gas Spring Bracket

D3953-21

D3969-3

Location Loc Qty ST075 12 97714 12 ST077 6 94146 6

16.0000 \*\*

Spring (Basket Lid)

Location Loc Qty Loc Code ST262 10 91844 10

100

Each

6

6

ST272 97050

DQA: Date:												
NCR: Y	es / No				WORK ORDER NON-	CON	FORN	MANCE / UPI	DATE			
			,,		· · · · · · · · · · · · · · · · · · ·			1.44		QA Closed:	Date	:
Work Orde	r·				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orac					Rework	7		Skid-tube	Crosstube	]	Water Jet	Engineering
Part N	lo.				Scrap	1	Machining Small Fa			Pro	d. Eng. Coor.	Quality
					Use-as-is	1 I	Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo		·		Work Order Update	Large Fab			Composite	]	Supplier	
Root		T		Descri	ption of work order update	   Ini	itial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	1	ef Eng		ription	Date	Verification	QC Inspector
Doc/Data	Jule	- Step	7.7									
Equip/Tooling				•		İ			•		·	
Operator												
Material												
Setup												
Other										Į.		
Process												
Supplier												
Training		ļ										
Unapproved										<u> </u>		
						AULT	CATE	GORY				
Landir	ng Gear			<b></b>	General					7	Г	
	Bending				Bend	$\mathbf{H}$	Grain		<u> </u>	Ovalized	-	Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	<b></b>	lardwa			Over/Under	<b>)</b> -	Temperature/Cure
	Cracks			_	Broken/Damaged	-	•	on Incomplete		Part Incorre	<b>⊢</b>	Weld
	Crushed/	Crimped	-	<u> </u>	Burrs	$\vdash$		ions Incomplete/l	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
Cuffs					Contamination	$\vdash$		nance	<u> </u>	Part Moved		
Heat Treat					Countersink	$\boldsymbol{\vdash}$	∕iislabe		ļ	Positioned V		¬
	Inspectio		Tube		Cut Too Short	<b> </b>	∕lisreac	i		Power Loss/	Surge	Other
ļ	Ripples in			_	Drill Holes	$\vdash$	Offset					
	Torque W	/aves in E	Extrusion	n	Drawing		Out of C	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:19:35 PM

Work Order ID: 100156

Parent Item:

D4030-041

\*100156\* \*D4030-041\*

Parent Item Name: Long Basket Assembly (350)

Purchased

Purchased

Purchased

Purchased

No

No

100

Each

87.0000

Loc Code

Start Qty: 1.00 \*\*

**Start Date: 4/18/13** 

Required Date: 5/02/13 Required Qty: 1.00

\*AN3-14A\*

AN3-14A

AN3-16A \*AN3-16A\*

**Location** 

Location

GA

ST352

Location

GA

ST337

ST512

123759

100

Loc Oty

Loc Qty

Loc Qty

36

36

116

50

66

Each

87

87

47

47

55

Each

102.0000

Loc Code

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AN5-17A \*AN5-17A\*

No

No

122407 123900

117872

124215

124805

124805

117441

8 47 100

Each

152.0000

Loc Code

\*\*

AN4-12

Location ST356 122800 Loc Oty 71 21 50

100

Loc Code

71.0000

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NCR: Ye	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE  QA Closed: Date:														
Work Order	•				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No	D				Rework Scrap Use-as-is Work Order Update		!	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other			
Root			T	Descr	ription of work order update	Ti	nitial	Act	ion	Sign &					
Cause	Date	Step	Qty	2 0 0 0	or Non-conformance	- 1	ief Eng		iption	Date	Verification	QC Inspector			
oc/Data quip/Tooling perator															
1aterial etup	<del>-</del>														
rocess upplier raining	<del>-</del>														
Inapproved						Ŀ									
					<del></del>	FAUL	T CATE	GORY							
Landing	g Gear			_	General	_	3		<del></del>	<b>7</b>		7			
	Bending				Bend	<u> </u>	Grain		<u> </u>	Ovalized	_	Pressure/Forced			
L	Centre I	Not Conce	ntric to	o/s	BOM/Route	<u> </u>	Hardwa		<u> </u>	Over/Under		Temperature/Cure			
L	Cracks			L	Broken/Damaged		4	ion Incomplete		Part Incorre	<del></del>	Weld			
L	Crushed	I/Crimped	-		Burrs		Instruct	tions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
	Cuffs				Contamination	L	Mainte	enance		Part Moved					
	Heat Tre	eat			Countersink		Mislabe	eled		Positioned V	Vrong	-			
	Inspecti	on Strip ir	Tube	Ī.	Cut Too Short		Misread	d		Power Loss/	Surge	Other			
	Ripples	in Bend		Γ	Drill Holes		Offset								
T	Torque	Waves in	Extrusio	n	Drawing		Out of	Calibration							
	_	Sequence			Finish		Out of Sequence								
<u> </u>	Wave/Twist in Tube Folio							Outside Dimensions							

DQA:

Date:

April-18-13 1:19:35 PM

Work Order ID: 100156

Parent Item:

D4030-041

\*100156\* \*D4030-041\*

Location

Location

ST342

ST342

Parent Item Name: Long Basket Assembly (350)

AN310-4

Purchased

Purchased

Purchased

100

Each

72.0000

Loc Code

**Start Date: 4/18/13** 

Start Qty: 1.00

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Required Qty: 1.00

Required Date: 5/02/13

No

\*AN310-4\* NUT

No

122800 124221

123831

124221

123265

123900

124291

ST506

70 100 Each

Loc Oty

72

2

86.0000

Loc Code

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\*\*

\*AN310C4\*

AN310C4

No

Loc Qty 86 2

84 100 Each 4,739.000

\*MS21042I3\*

MS21042L3

<u>Location</u>	Loc Oty	Loc Code
FP001	3	
122141	3	
GA	114	
122452	114	
ST314	268	
117885	32	
119017	55	
119075	138	

43

4354

974

3380

Equip/Tooling Operator Material Operator Operato												DQA:	Da	te: _				
Work Order:    Part No.	NCR: Y	es / No	1		WOR	K ORDER NON-	NFORM				-							
Part No.							QA Closed:	Da	te:	W								
Rework Scrap   Skid-tube   Crosstube   Skid-tube   Prod. Eng. Coor   Quality	NA a ala Onda		•			DISPOSITION AGAIN						T DEPARTMENT/PROCESS						
Part No.	Work Orde	Τ	1			Rework [	٦		Skid-tube	Crosstu	be	]	Water Jet	П	Engineering			
NCR No.    Note    Part N	0	*		İ	<b>}</b> —-	-					Pro		H					
Root Cause Date Step Qty Or Non-conformance Chief Eng Description Sign & Verification QC Inspector Doc/Data   Doc/Data   Cause   Date	, aren	··	,		<del></del>	I 1			- 1			4	=		Other			
Root Cause Date Step Qty Or Non-conformance Chief Eng Description Date Verification QC Inspector  Doc/Data Equip/Tooling Coperator Chief Eng Description Date Verification QC Inspector  Doc/Data Equip/Tooling Coperator Chief Eng Description Date Verification QC Inspector  Doc/Data Equip/Tooling Coperator Chief Eng Description Date Verification QC Inspector  Doc/Data Equip/Tooling Coperator Chief Eng Description Date Verification QC Inspector  Doc/Data Equip/Tooling Coperator Chief Eng Description Date Verification QC Inspector  Doc/Data Equip/Tooling Coperator Chief Eng Description Date Verification QC Inspector  Doc/Data Equip/Tooling Coperator Chief Eng Description Date Verification QC Inspector  Doc/Data Equip/Tooling Coperator Chief Eng Description Date Verification QC Inspector  Doc/Data Verification QC Ins	NCR N	0.			Wo	ork Order Update			Large Fab	Compos	ite	]	Supplier					
Date   Step   Qty   Or Non-conformance   Chief Eng   Description   Date   Verification   QC Inspector													<u> </u>					
Doc/Data   Cquip/Tooling   Coperator   Cquip/Tooling   Coperator   Cquip/Tooling   Cquip/Tooli	Root				•		1					1 -						
Equip/Tooling Operator Material Operator Operato	Cause	Date	Step	Qty	or Non-co	onformance	Cr	nief Eng	Des	scription		Date	Verificatio	n	QC Inspector			
Operator Material Setup Other Other Frocess Supplier Training Unapproved  I Bending Centre Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Contar Not Concentric to O/S I Bom/Route I Inspection Incomplete I Instructions Incomplete I Part Incorrect I Weld Wrong Stock Pulled Wrong Stock Pulled Positioned Wrong Inspection Strip in Tube I Inspection Strip in Tube I Inspection Strip in Tube I Countersink I Mislabeled I Power Loss/Surge I Other	Doc/Data		-															
Material Setup Cother Countering Countersink Countersing Countersink Countersing Countersi	Equip/Tooling																	
Setup Other Process Supplier Training Unapproved Unappr	Operator																	
Other Process Supplier Training Unapproved U	Material							:										
Process Supplier Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved  Training Unapproved Unapproved  Training Unapproved Unap	Setup													Ì				
Supplier   Training   Unapproved   FAULT CATEGORY   FAULT	Other												[					
Training Unapproved	Process	_																
Landing Gear   General   Grain   Ovalized   Pressure/Forced   Hardware   Over/Under tolerance   Temperature/Cure   Weld   Crushed/Crimped   Burrs   Instructions Incomplete   Part Lost/Missing   Wrong Stock Pulled   Heat Treat   Countersink   Mislabeled   Misread   Pressure/Forced   Part Moved   Part M	1 -	_																
FAULT CATEGORY  Landing Gear  Bending Bend Centre Not Concentric to O/S Cracks Broken/Damaged Crushed/Crimped Cuffs Cuffs Countersink Burs Countersink Countersink Countersink Cuffs Cushed/Crimpied Cuffs Countersink Cuffs Cushed/Crimpied Cushed/Crimpied Cushed/Crimpied Countersink Cushed/Crimpied Cushe	1 T	_																
Landing Gear  Bending Bending Bend Centre Not Concentric to O/S BOM/Route Broken/Damaged Bend Bend Bend Bend Bend Bend Bend Be	Unapproved			<u> </u>		,		T 64 TE					<u> </u>					
Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other			- 1				FAUI	LICATE	GORY	<del></del>								
Centre Not Concentric to O/S Cracks Broken/Damaged Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube  Centre Not Concentric to O/S BOM/Route Hardware Hardware Inspection Incomplete Hardware Inspection Incomplete	Landin					General		Crain				Ovalizad			Pressure/Forced			
Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other		_		omeria ea O	<u>  </u>	auta	┢	-	ro		$\vdash$	⊣	tolerance	$\vdash$				
Crushed/Crimped.  Cuffs Contamination Heat Treat Inspection Strip in Tube  Cut Too Short  Burrs Instructions Incomplete/Unclear Maintenance Part Lost/Missing Part Lost/Missing Part Moved Part Moved Positioned Wrong Power Loss/Surge Other			Not Conce	entric to O/	<b>—</b>		-	-			-	-  '		$\vdash$	•			
Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other		<del></del> -	d/Crimpod	1	<b>  </b>	Damageu	-	-1		o/Linclear		-∤						
Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other		_	u/Crimped		<del>  </del>	nation		-1		e, oricical	-	┥		ш	1			
Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other			ont		$\vdash$		-	-				-4						
	-			n Tuhe	$\vdash$		$\vdash$	-			-	⊣	_		Other			
				·	Drill Ho			Offset	•		<u> </u>	J. 2.1.5. 2000,	0-					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 1:19:36 PM

Work Order ID: 100156

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

\*100156\* \*D4030-041\*

123900

**Start Date:** 4/18/13

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337.0000

137.0000

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

\*MS21042L5\*

Nut

MS21042L5

 Location
 Loc Oty
 Loc Code

 ST506
 337

100

337 337

Each

Each

<u>Code</u>

123900

\*MS24665-151\*

Cotter Pin

MS24665-151

 Location
 Loc Oty
 Loc Code

 GA
 28

100

17566 28 ST323 109 122802 59

12280

MS24665-300

Purchased No

Purchased

Purchased

No

No

124859 50 100 Each 219.0000

182

2 \*\*

13/4/30 6

\*MS24665-300\*

Cotter Pin

 Location
 Loc Oty
 L

 GA
 37

 118234
 37

 ST299
 182

124555

Loc Code

124500

1		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
		OA Clacad:	Data:	

										QA Closed.	Date.						
Work Orde	ar.	-				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Work Orac		•				Rework		Skid-tube	Crosstube		Water Jet	Engineering					
Dart N	۱o	į				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality					
raiti	NO			<u></u>		Use-as-is	B	moforming	Finishing		e/Packaging	Other					
NICDA	do.	ı				Work Order Update	111611	Large Fab	Composite	1100,001	Supplier						
NCR No.						Work Order Opdate		Large Tab	composite								
Root		Desc			Descri	ption of work order update	Initial	Act	tion	Sign &							
Cause	D.	ate	Step	Qty	(	or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector					
Doc/Data		÷Ļ															
Equip/Tooling		1															
Operator		-	:					1									
Material		! !															
Setup		!															
Other		i															
Process																	
Supplier		į								;							
Training		i	'														
Unapproved																	
						F.A	AULT CATE	GORY			45 45 cm starter						
Landir	ng Gear					General				•	<u></u>	,					
	Ben	ding	i			Bend	Grain			Ovalized		Pressure/Forced					
	Cen	tre No	ot Concer	ntric to	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure					
	Crac	ks	,			Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld					
	Crus	shed/0	Crimped.			Burrs	Instruc	tions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled					
	Cuff	s				Contamination	Maint	enance		Part Moved							
	Hea	t Trea	t			Countersink	Mislab	eled		Positioned V	Vrong	_					
	Insp	ection	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other					
	Ripp	oles in	Bend			Drill Holes	Offset										
	Torque Waves in Extrusion					Drawing	Out of	Calibration									
	Turning Sequence					Finish	Out of Sequence										
	Wave/Twist in Tube Folio					Folio	Outsid	e Dimensions									

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April-18-13 1:19:36 PM

Work Order ID: 100156

Parent Item:

D4030-041

Parent Item Name: Long Basket Assembly (350)

\*100156\* \*D4030-041\*

**Start Date:** 4/18/13

Required Date: 5/02/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Purchased

Purchased

No

No

No

100

Each

1,878.000

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\*NAS1149F0432P\*

Washer

<b>Location</b>	<u>Loc</u>	Oty	Loc Code			
ST295		1878				
122151		2				
123522		4				
123900		172				
124580		400			12458	
124859		300				
125268		1000				
	100	Each	728.0000	4	4 —	
			*	*		

Purchased \*NAS1149F0563P\*

Washer

NAS1149F0563P

<b>Location</b>	Loc	e Qty	Loc Code
ST295		728	
121350		728	
	100	Each	8,690.000

\*NAS1149F0332P\*

WASHER

NAS1149F0332P

**Location** Loc Qty Loc Code GA 182 122063 182 ST294 158 122063 158 ST295 3 123352 3 st510 8347

8347

123900

NCR:																	
											QA Closed:	Date:	S				
Work Ord	or.					DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part No.						Rework Scrap	Skid-tube Crosstube  Machining Small Fab			<u> </u>	Pro	Engineering Quality					
NCR No.						Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite				Rec/Store/Packaging Other Supplier							
Root		:			Descri	ption of work order update		nitial	Acti	ion	Sign &						
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector				
Doc/Data		!										İ					
Equip/Tooling							İ										
Operator	Ш																
Material																	
Setup	Ш	ļ															
Other	Ш	1															
Process				•													
Supplier		!															
Training	Ш																
Unapproved							1_					<u> </u>					
							AUL	T CATE	GORY			<del></del>					
Landing Gear General								1	•	_	<del>-1</del>		<b>.</b> .				
Bending						Bend	<u></u>	Grain		<u> </u>	Ovalized	_	Pressure/Forced				
	Ш	Centre No	ot Conce	ntric to O	/s	BOM/Route	<u></u>	Hardwa		<u> </u>	Over/Unde	<del></del>	Temperature/Cure				
	Ш	Cracks			<u> </u>	Broken/Damaged	$\vdash$	- 1	ion Incomplete	<u> </u>	Part Incorre	<del>}</del>	Weld				
1		Crushed/	Crimped.			Burrs	1	Instruct	tions Incomplete/U	Inclear	Part Lost/N	Wrong Stock Pulled					

Maintenance

Out of Calibration

Out of Sequence Outside Dimensions

Mislabeled

Misread

Offset

DQA:

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Date:

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

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April-18-13 1:19:36 PM

Work Order ID: 100156

Parent Item:

D4030-041

Parent Item Name: Long Basket Assembly (350)

\*100156\* \*D4030-041\*

**Start Date:** 4/18/13

Start Qty: 1.00

Required Date: 5/02/13

Required Qty: 1.00

NAS1149C0432R \*NAS1149C0432R\*

Washer

Purchased

No

100

Each

1,686.000

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Location Loc Qty Loc Code ST292 1686 119124 122441 1680

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE															
											•	QA Closed:	Da	ite:	
Work Orde	ar.	,				DISPOSITION				AGAINST DE	ΞF	PARTMENT	PROCESS		
Part No						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstu  Machining Small F  Thermoforming Finish  Large Fab Compos			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier				Engineering Quality Other
Post	-	:	T		Descri	ption of work order update		nitial	Δct	tion	Ī	Sign &			
Root Cause		Date	Step	Qty		or Non-conformance		ief Eng		ription		Date	Verification	n	QC Inspector
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Material											-				
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Other											ļ				
Process							Į								
Supplier			1					٠			ļ				
Training			· ·												
Unapproved			<u> </u>	<u></u>			<u> </u>								
							AUL	T CATE	SORY						
Landii			į.		_	General	_	1			_	l		_	la <i>1</i> 5 (
	-	Bending				Bend	<u></u>	Grain		<u> </u>	-	Ovalized		-	Pressure/Forced
		Centre N	ot Concer	ntric to	o/s	BOM/Route	_	Hardwa			-1	Over/Under		<u> </u>	Temperature/Cure
	_	Cracks <sup>1</sup>				Broken/Damaged	_	4 `	ion Incomplete	<u> </u>	$\dashv$	Part Incorre		<u> </u>	Weld
	-	Crushed/	Crimped.			Burrs		4	ions Incomplete/l	Unclear	-	Part Lost/M	ssing	L_	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	_	-	Part Moved			
		Heat Trea	at			Countersink		Mislabe	led		-	Positioned V			1
		Inspectio	n Strip in	Tube		Cut Too Short		Misread				Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

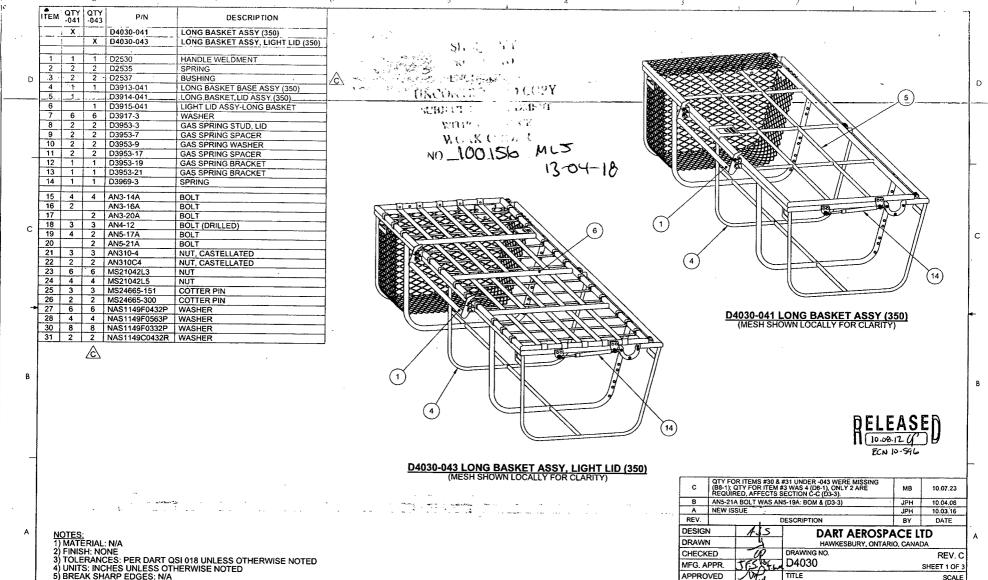
Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

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6) IDENTIFICATION: N/A 7) WEIGHT: -041: 72 lbs APPROX -043: 57 lbs APPROX

LONG BASKET ASSY (350) DE APPR. DATE 10.07.23

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